

Tuesday, June 23, 2015 3:15:03 PM

133924

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Cable Guard

Start Date: 6/16/15 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/24/15 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MCS Date: JUN 21 2015 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D205-665	G

100 Document Control

0.00

100

DC

Doc.Control -USB or Paperwork

Memo

0.00

PHOTOCOPY BLUE FILE AND CREATE LABELS AS PER PPPD205-665-019 CHG001

110 Pick Kit

0.00

110

Packaging

Packaging

Memo

0.00

120 QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

2x

2 NOV 6 2015

2x DAS NOV 17 2015
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 133924

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133924

Page 2

Item ID: D205-665-019 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cable Guard
 Start Date: 6/16/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/24/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130						2X	DAS 28 9-89	NOV 17 2015	
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-665-019								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140						MUS		NOV 17 2015	
QC	Memo	0.00							
Quality Control									

SH 20151117

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
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Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 133924

133924

Parent Item: D205-665-019

D205-665-019

Parent Item Name: Cable Guard

Start Date: 6/16/15

Required Date: 6/24/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 11.11.08 new issue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2570

Manufactured

No

110

Each

441.0000

10

1020

**

137171

DAS
28
9-89

DAS
28
9-89

D2570

Bushing

Location

Loc Qty

Loc Code

FG

12

88781

12

FP001

195

133432

195

ST008

4

116925

4

ST012a

230

129830

130

132548

100

D4445-1

Manufactured

No

110

Each

2.0000

1

**

DAS
28
9-89

DAS
28
9-89

D4445-1

Cable Guard

Location

Loc Qty

Loc Code

ST260B

2

124689

2

D4506-1

Manufactured

No

110

Each

11.0000

1

**

DAS
28
9-89

DAS
28
9-89

D4506-1

Washer

Location

Loc Qty

Loc Code

ST112

11

113739

10

78378

1

DAS
28
9-89

NOV 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

Page 2

Tuesday, June 23, 2015 3:15:03 PM

Work Order ID: 133924

133924

Parent Item: D205-665-019

D205-665-019

Parent Item Name: Cable Guard

Start Date: 6/16/15

Required Date: 6/24/15

Start Qty: 1.00

Required Qty: 1.00

AN4-47A

Purchased

No

110

Each

29.0000

4

4

AN4-47A

BOLT

DAS
28
9-89

Location

Loc Qty

Loc Code

ST341

29

m126193

12

m130325

17

**

48

AN4-50A

Purchased

No

110

Each

2.0000

1

1

AN4-50A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

ST340

2

m126193

1

m128199

1

**

1x
1x

NOV 6 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Picklist Print

Page 3

Tuesday, June 23, 2015 3:15:03 PM

Work Order ID: 133924

133924

Parent Item: D205-665-019

D205-665-019

Parent Item Name: Cable Guard

Start Date: 6/16/15

Required Date: 6/24/15

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

4,534.000

5

10X 133363

DA: 26 9-8

2

MS21042L 4

Locknut

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

10

m124231

10

GA

160

m127813

160

ST260a

4062

m130799

56

m131803

6

m132262

1000

m132382

3000

ST305

302

m128300

8

m130388

7

m130922

97

m131618

12

m132123

178

NOV . 6 2015

7-8
6
9-89

Tuesday, June 23, 2015 3:15:03 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																																																																				
Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																																																																				
Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																				
Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																				
Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐																																																																				
Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																				
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																				
Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																				
OTHER : _____																																																																							

Work Order ID 133924

Tuesday, June 23, 2015 3:15:03 PM

133924

Page 1

Item ID: D205-665-019

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Cable Guard

Stop ***NS2***

Start Date: 6/16/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/24/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: ML5Date: JUN 24 2015

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D205-665

G

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

PHOTOCOPY BLUE FILE AND CREATE LABELS AS PER PPPD205-665-019 CHG001

NOV 16 2015

ML5(2)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

NOV 6 2015

(2)

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

PARTS LIST

QTY -011	QTY -013	QTY -015	QTY -017	QTY -019	PART NUMBER	DESCRIPTION
X					D205-665-011	CABLE GUARD INSTALLATION
	X				D205-665-013	CABLE GUARD INSTALLATION
		X			D205-665-015	CABLE GUARD INSTALLATION
			X		D205-665-017	CABLE GUARD INSTALLATION
				X	D205-665-019	CABLE GUARD INSTALLATION
1					D2886-1	GUARD
	1				D2886-3	GUARD
			1		D3990-1	GUARD
		1			D2916-1	GUARD
		1			D2916-3	GUARD
		1			D2916-5	GUARD
		1			D2916-7	GUARD
		4			D2915	BUSHING
1		2	1		D2529	WASHER
6	6	8	2	10	D2570	BUSHING
				1	D4445-1	GUARD
				1	D4506-1	WASHER
4	3	4	2	4	AN4-47A	BOLT
				1	AN4-50A	
		4			AN4-55A	BOLT
4	3	8	2	5	MS21042L4 (OR -4)	NUT
1		2	1		NAS1149D0463J	WASHER (OR AN90JD416)

WEIGHT AND BALANCE

Installation	Weight	Longitudinal	
		Arm	Moment
D205-665-011	2.22 lb 1.01 kg	145.2 in 3.69 m	322 in-lb 3.73 m-kp
D205-665-013	2.20 lb 1.00 kg	101.7 in 2.58 m	224 in-lb 2.58 m-kp
D205-665-015	6.96 lb 3.16 kg	117.2 in 2.97 m	816 in-lb 9.40 m-kp
D205-665-017	0.70 lb 0.32 kg	68.5 in 1.74 m	48 in-lb 0.56 m-kp
D205-665-019	4.81 lb 2.18 kg	118.7 in 3.01 m	571 in-lb 6.56 m-kp

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 12.04.25
CERT. NO.: SH96-88
ISSUE NO.: 3

DESIGN	<u>DE</u>	DART AEROSPACE LTD	
DRAWN	<u>DC</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>DE</u>	DRAWING NO.	REV. G
MFG. APPR.	N/A	D205-665	SHEET 3 OF 10
APPROVED	<u>[Signature]</u>	TITLE	SCALE
DE APPR.	<u>[Signature]</u>	CABLE GUARD INSTALLATION	NTS
DATE	12.04.25	COPYRIGHT © 1999 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	